

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65183



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Friday, January 07, 2011 10:38:40 AM

Item ID:	D350-591-215	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Heli-Access-Step, Short LH					
Start Date:	1/7/2011	Start Qty:	2.00		Cust Item ID:	
Required Date:	1/14/2011	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		<i>Sulochi</i>		<i>(42)</i>			
130 Large Fab Large Fab	Large Fab Memo 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8780, weld Fwd End Plate as per QSI 004 & Dwg D3168 A/R Aluminum Rod <i>m108436</i> 3-Grind End Plate flush <i>m115928</i>	0.00 0.00		<i>11.01.17</i>		<i>2</i>	<i>0</i>		
140 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				<i>2</i>	<i>0</i>	<i>3E11/04/18</i>	

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 65183

Friday, January 07, 2011 10:38:40 AM



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Item ID: D350-591-215

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Short LH

Start Date: 1/7/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				22 24			
160 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				264			
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				2			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 65183

Friday, January 07, 2011 10:38:40 AM



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Item ID: D350-591-215

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Short LH

Start Date: 1/7/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 Large Fab	Large Fab	0.00				2	0		
Large Fab	Memo Rivet Leg Assembly as per Dwg D3168	0.00							
200 Large Fab	Large Fab	0.00				2	0		
Large Fab	Memo 1-Bevel Aft end for welding 2-Inspect for foreign object as per QSI 024 3-Weld Aft End Plate as per QSI 004 & Dwg D3168 A/R Aluminum Rod <u>M108436</u> 4-Grind End Plate flush	0.00							
210 QC	QC9- Inspect visual per QSI004- Fusion Welds	0.00				2	0		
Quality Control	Memo	0.00							BE 11/6/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 65183

Friday, January 07, 2011 10:38:40 AM



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Item ID: D350-591-215

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Short LH

Start Date: 1/7/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

230

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

240

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



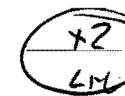
Powdercoat

Memo

0.00

Powder Coating

START TIME: 2:25
OVEN TEMPERATURE: 320°
FINISH TIME: 2:55



2 BR 11-01-20.

2 BR 11-01-20.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 65183

Friday, January 07, 2011 10:38:40 AM

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Item ID: D350-591-215

Accept

Revision ID:

Item Name: Heli-Access-Step, Short LH

Start Date: 1/7/2011 Start Qty: 2.00

Required Date: 1/14/2011 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
StopSequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

Wing Walk

Memo

M115790

0.00

0.00

11/01/21

X2

/

260



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

8.11.14/26

2
24

270



Packaging

Packaging

Pick Kit

Memo

0.00

0.00

11/1/25

20 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID 65183

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Friday, January 07, 2011 10:38:40 AM

Item ID: D350-591-215

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Short LH

Start Date: 1/7/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

280

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

8x101/26

22
24

Quality Control

290

Packaging

0.00



Packaging

Memo

0.00

Identify and pack for shipping as per PPP D350-591-215

Location: 9PPP Rev: 2

11/12/26 SF 20

300

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

11/01/26 HJ

Quality Control

CL 11/01/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 1

Friday, January 07, 2011 10:38:44 AM

Work Order ID: 65183

Parent Item: D350-591-215

Parent Item Name: Heli-Access-Step, Short LH

Start Date: 1/7/2011

Required Date: 1/14/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev: A ☐ 02.10.17 ☐ New issue ☐ KJ/RF
 IPP Rev: B 06-06-19 Added D2732-030 AS PER DSI9294 JLM
 IPP Rev: C 06-06-27 Revised as per DSI9340 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C

Manufactured

No

110

Each

17.7000

0.5

1



Step Extrusion

Location

Loc Qty

Loc Code

WA

17.7

55214

3.42

58544

1

61208

13.28

D2622-120CRevC1

Manufactured

No

110

Each

0.0000

0.5

1



Step Extrusion

D3067-1

Manufactured

No

130

Each

116.0000

1



End Plate

Location

Loc Qty

Loc Code

WA

116

60141

2

62664

6

63550

108

D3067-1RevA

Manufactured

No

130

Each

0.0000

1



End Plate

11.01.14

1

11.01.17 863550

2 11.01.17 863550

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

Friday, January 07, 2011 10:38:45 AM

Work Order ID: 65183

Parent Item: D350-591-215

Parent Item Name: Heli-Access-Step, Short LH

Start Date: 1/7/2011

Required Date: 1/14/2011

Start Qty: 2.00

Required Qty: 2.00

✓ D3169-1

Manufactured No

130

Each

15.0000

1

2



Support



11.01.17

Location

Loc Qty

Loc Code

WA

15

26685

15

2

perm. chg
D3169-1RevA

Manufactured No

130

Each

0.0000

1

2



Support



✓ D3077-1

Manufactured No

180

Each

34.0000

2

4



Step Leg



11.01.20

Location

Loc Qty

Loc Code

WA

34

26684

10

35817

24

4

perm. chg
D3077-1RevB

Manufactured No

180

Each

0.0000

2

4



Step Leg



D3170-1

Manufactured No

180

Each

35.0000

2

4



Spacer



11.01.20

Location

Loc Qty

Loc Code

Mezz

325113

35

35824

35

4

D3170-1RevB

Manufactured No

180

Each

0.0000

2

4



Spacer



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Friday, January 07, 2011 10:38:45 AM

Work Order ID: 65183

Parent Item: D350-591-215

Parent Item Name: Heli-Access-Step, Short LH

Start Date: 1/7/2011

Required Date: 1/14/2011

Start Qty: 2.00

Required Qty: 2.00

MS20600-AD4W4

Purchased

No

180

Each

2,351.000

12

24



Rivets



11.01.20

Location

Loc Qty

Loc Code

ST321

2351

113368

38

114181

11

114718

2

115573

147

115640

31

116022

622

116188

1500

24

D3067-1

Manufactured

No

200

Each

116.0000

1

2



End Plate



11.01.20

Location

Loc Qty

Loc Code

WA

116

60141

2

62664

6

63550

108

2

D3067-1RevA

Manufactured

No

200

Each

0.0000

1

2



End Plate



AN3-35A

Purchased

No

270

Each

168.0000

2

4



Bolt



11/1/25 SL E

Location

Loc Qty

Loc Code

ST353

168

116191

100

116419

18

116549

50

✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

Friday, January 07, 2011 10:38:45 AM

Work Order ID: 65183

Parent Item: D350-591-215

Parent Item Name: Heli-Access-Step, Short LH

Start Date: 1/7/2011

Required Date: 1/14/2011

Start Qty: 2.00

Required Qty: 2.00

AN4-11A

Purchased

No

270

Each

300.0000

6

12



Bolt



11/12/55

Location

Loc Qty

Loc Code

ST357

300

110382

100

115316

200

12

AN4-13A

Purchased

No

270

Each

265.0000

4

.8



Bolt



1116669 11/12/55

Location

Loc Qty

Loc Code

ST357

265

116191

265

AN4-16A

Purchased

No

270

Each

154.0000

4

.8



Bolt



11/12/55

Location

Loc Qty

Loc Code

ST358

100

116400

100

ST360

54

115422

54

AN960JD10

NAS1149D0363J

Purchased

No

270

Each

8.0000

4

.8



Washer



1116025 11/12/55 (20)

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

2

105792

2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 5

Friday, January 07, 2011 10:38:45 AM

Work Order ID: 65183

Parent Item: D350-591-215

Parent Item Name: Heli-Access-Step, Short LH

Start Date: 1/7/2011

Required Date: 1/14/2011

Start Qty: 2.00

Required Qty: 2.00

AN960JD416 NAS1149D0463J Purchased No

270 Each 30.0000 12 24



Washer



1116304 11/1/255

Location Loc Qty Loc Code

ST300 24

113288 24

ST356 6

115622 6

D2230-1 Manufactured No

270 Each 166.0000 2 4



Lug



11/1/255

Location Loc Qty Loc Code

ST430 80

63998 80

ST476 86

62665 2

63319 4

64423 80

270 Each 0.0000 2 4

D2230-1Rev6 Manufactured No



Lug



4

D2230-3 Manufactured No

270 Each 94.0000 2 4



Lug



B65067 11/1/255 (20)

Location Loc Qty Loc Code

ST476 94

55452 2

63312 12

64422 80

Friday, January 07, 2011 10:38:45 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

Friday, January 07, 2011 10:38:45 AM

Work Order ID: 65183

Parent Item: D350-591-215

Parent Item Name: Heli-Access-Step, Short LH

Start Date: 1/7/2011

Required Date: 1/14/2011

Start Qty: 2.00

Required Qty: 2.00

D2230-3RevG

Manufactured No

270 Each

0.0000

2

4



n/a extra

Lug

D2732

Manufactured No

270 f

571.8793

0.5



11.1.25.58

Rubber Extrusion

Location

Loc Qty

Loc Code

ST410

500

64283

500

ST412

71.879279

56516

71.879279

D2732RevB1

Manufactured No

270 f

0.0000

0.5

1



n/a extra

Rubber Extrusion

D2856-400 @ 7.2" x 1/2" kit

Manufactured No

270 f

275.2930

0.6

1.2



11.1.25.58

Abraison Strip

Location

Loc Qty

Loc Code

ST403

275.2930421

56626

0.00004211

59920

59.293

63735

216

D2856-400RevA

Manufactured No

270 f

0.0000

0.6

1.2



n/a extra

Abraison Strip

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Friday, January 07, 2011 10:38:45 AM

Work Order ID: 65183

Parent Item: D350-591-215

Parent Item Name: Heli-Access-Step, Short LH

Start Date: 1/7/2011

Required Date: 1/14/2011

Start Qty: 2.00

Required Qty: 2.00

MS21042L3

Purchased

No

270

Each

3,286.000

2

4



Nut



11/1/2011

Location

Loc Qty

Loc Code

ST300

3282

114784

9

115835

773

116391

900

116540

800

116549

800

4

MS21042L4

Purchased

No

270

Each

5,104.000

6

12



Nut



11/1/2011

Location

Loc Qty

Loc Code

ST300

5072

1123143

2

115589

10

115621

560

116188

3500

116548

1000

12

D2230-1RevF

Manufactured

No

280

Each

0.0000

2

4



Lug



D2230-3RevF

Manufactured

No

280

Each

0.0000

2

4



Lug



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DESIGN <i>ap</i>	DRAWN BY <i>ap</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3168	REV. A SHEET 1 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, LOW SHORT SCALE NTS	
A	02.09.11	NEW ISSUE	

RELEASED
02.09.20 *#*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *65183* *2811-01-7*

Part No.	Description	QTY -041	QTY -042
D3168-041	Step Assembly, Low Short (LH)	X	
D3168-042	Step Assembly, Low Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3067-1	END PLATE	2	2
D3077-1	STEP LEG	2	2
D3169-1	SUPPORT	1	1
D3170-1	SPACER	2	2
MS20600AD4W4	RIVET	12	12

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3169-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

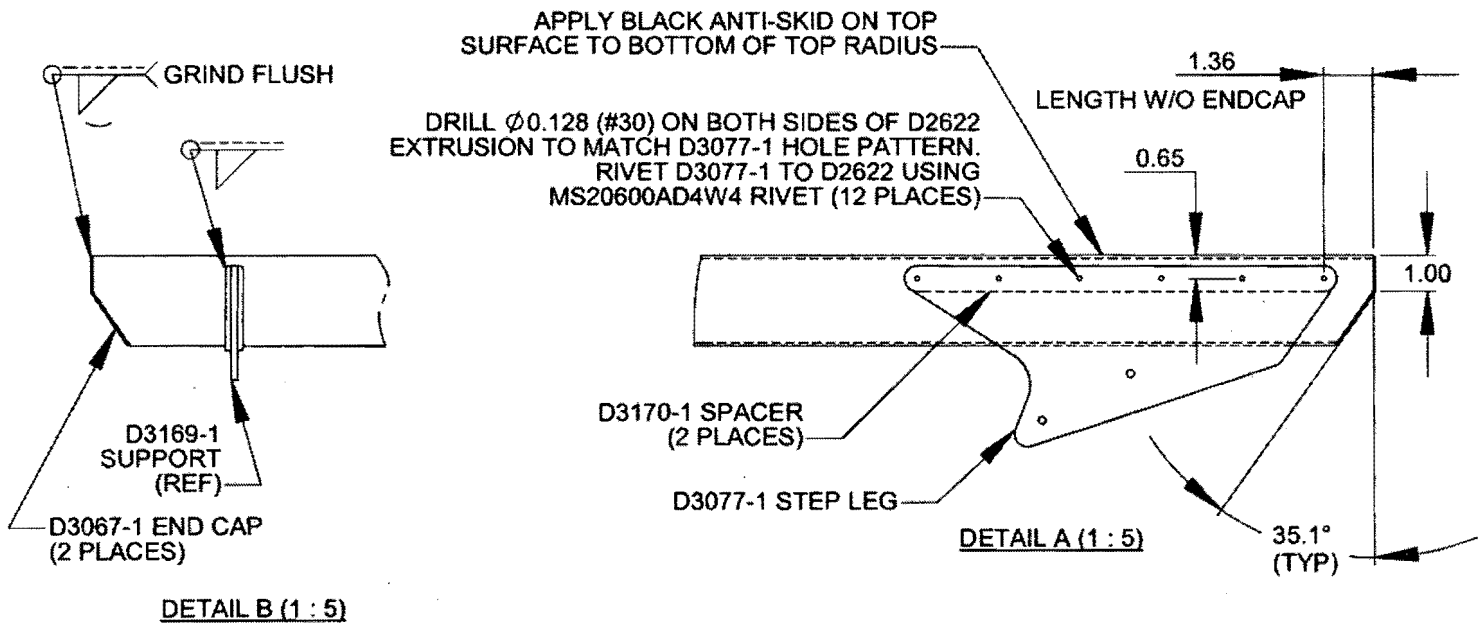
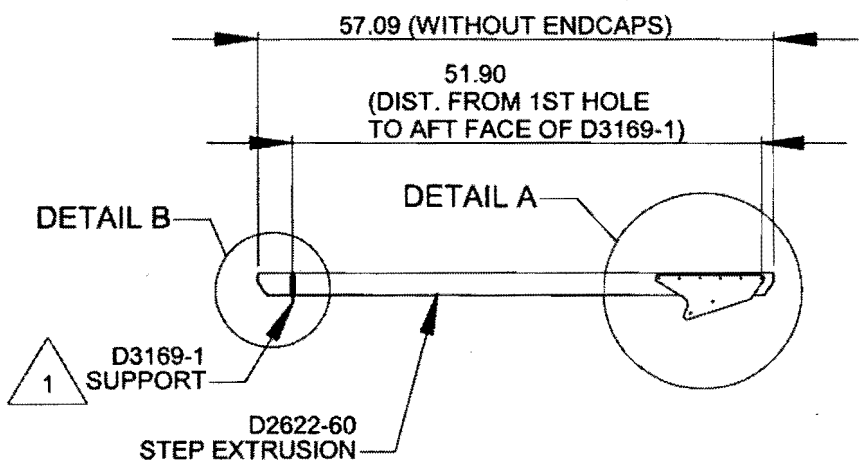
QA CONTROLLED

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. A
02.09.11	D3168	SHEET 2 OF 2
	TITLE	SCALE
	STEP ASSEMBLY, LOW SHORT	1:20

RELEASED
02.09.20

57.69
1.36
55.73

w/o 65183



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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER
REF CANADIAN STC: SH92-6
REF FAA STC: SH967NE

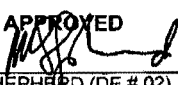
For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying crosstube diameters and to improve fit, as indicted in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.





For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

Qty -213	Qty -214	Qty -215	Qty -216	Part Number	Description
X				D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

w/o 65183

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01
APPROVED 
BY: D. SHEPHERD (DE # 02)
DATE: 09.08.05
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE	RF	09.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	NCA	DSI 9472	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BOLT ADDITION	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

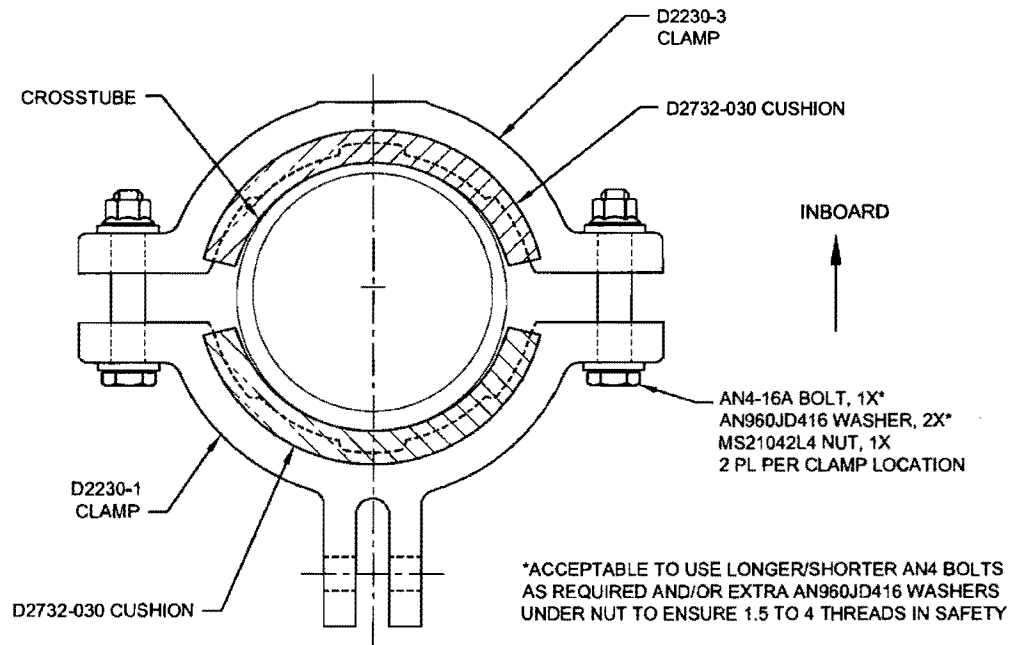


FIGURE 1: CLAMP DETAIL
OPTIONAL CLAMP CONFIGURATION

W/O 65183

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 09.08.05
CERT. NO.: SH92-6
ISSUE NO.: 11

DESIGN	<i>GP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>GP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>N/A</i>	DSI 9472	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BOLT ADDITION	NTS
DATE	09.08.05	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step™</i> , Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step™</i> , Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step™</i> , Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step™</i> , Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step™</i> , Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step™</i> , Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step™</i> , Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step™</i> , Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4		8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

REFERENCE

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER
REF CANADIAN STC: SH92-6
REF FAA STC: SH967NE

For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying cross-tube diameters and to improve fit, as indicated in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.

For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

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	X			D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED


BY: D. SHEPHERD (DE # 02)

DATE: 09.08.05
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE	RF	09.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. A
CHECKED	UP	DSI 9472	SHEET 1 OF 2
MFG. APPR.	N/A	TITLE	SCALE
APPROVED	AN	BOLT ADDITION	NTS
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